

Work Order ID 78780

78780

Page 1

January-16-12 7:41:00 AM

Item ID: D350-591-311

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Heli-Access-Step, Long LH

Stop *NS2*

Start Date: 16/01/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 09/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/01/16 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

Sizb3/01

MLJ 12/02/21
CO

110

0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/RAluminum Rod

3-Grind End Plate flush

119785
119712

Ae 12/02/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
120						10	0		
QC	Memo	0.00							
Quality Control									
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									

8/12/12/13

410

44

Ac 12/02/14

410

0

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

12 02 15 (10)

180

0.00

180

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/RAluminum Rod 119785

6-Grind End Plate flush

7-Install last rivet as per Dwg.

→ Ae 12/02/15

→ Ae 12-02-20
→ Ae 12/02/21

(X10)

6

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC10- Inspect visual per QSI004- ground welds	0.00							
190									
QC	Memo	0.00							
Quality Control									
200	QC5- Inspect part completeness to step on W/O	0.00							
200									
QC	Memo	0.00							
Quality Control									
210	Chemical Conversion Coat per QSI005 4.1	0.00							
210									
HandFinish	Memo	0.00							
Hand Finishing									

PC 12.02.21

10x Ø

12 - 02 - 21 (10)

10x M-1 12/02/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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 Start Date: 16/01/2012 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 09/03/2012 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
-----	--	------	--	--	--	--	--	--	--

220

Powdercoat

Powder Coating

Memo

START TIME: 10-20

OVEN TEMPERATURE: 3200 F

FINISH TIME: 10-50

0.00

230

Wing Walk as per dwg QSI005 4.4 Batch 1120/25 0.00

230

HandFinish

Hand Finishing

Memo

0.00

240

QC3- Inspect Part Finish

0.00

240

QC

Quality Control

Memo

0.00

10X ✓ M-12/02/23

10. (OP) / BR 122-23.

10X ✓ M-12/02/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

[Handwritten signatures and stamps]

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

Siz/b3/01

270

Packaging

0.00

270

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-311

Location: *hall*

Reub

[Handwritten signatures and stamps]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

Required Date: 09/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

MLJ 12/03/07
MF 12-03-01

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Picklist Print

January-16-12 7:41:05 AM

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Work Order ID: 78780

78780

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 16/01/2012

Required Date: 09/03/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A04.03.22New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified
by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3272-1		Manufactured	No			110	Each	30.0000	1	10			
D3272-1									**			12.01.09	
Step													

Location	Loc Qty	Loc Code
ST	378784	-10
WA		40
	77650	10
	77651	10
	77653	10

D3067-1		Manufactured	No			110	Each	127.0000	1	10			
D3067-1									**			12.01.11	
End Plate													

Location	Loc Qty	Loc Code
WA	78022	120
	78022	120
WA016		7
	67582	2
	68214	1
	76179	4

W/O:		WORK ORDER CHANGES					
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Work Order ID: 78780

78780

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 16/01/2012

Required Date: 09/03/2012

Start Qty: 10.00

Required Qty: 10.00

D3219-1 Manufactured No

110 Each 78.0000 2 20

D3219-1

Plate

**

12.02.12

Location

Loc Qty

Loc Code

WA016 B78763 78
73410 12
76226 14
77674 52

20

D3066-1 Manufactured No

180 Each 96.0000 2 20

D3066-1

Spacer

**

B79729 (x20) Ac 12/02/12

Location

Loc Qty

Loc Code

WA 70
77564 70
WA015 26
76180 26

20

MS20600-AD4W4 Purchased No

180 Each 2,386.000 16 160

MS20600-AD4W4

Rivets

**

B120308 (x160) Ac 12/02/15

Location

Loc Qty

Loc Code

ST321 2381
116188 59
117364 253
117601 200
117885 195
118840 1089
119860 30
119883 555
WA018 5
116712 5

160

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 16/01/2012

Required Date: 09/03/2012

Start Qty: 10.00

Required Qty: 10.00

D3065-041

Manufactured No

180

Each

12.0000

1

10

D3065-041

Step Leg Assembly Hi

**

B78797 (x10) Ac 12/02/15

Location

Loc Qty

Loc Code

WA

12

66149

0

77054

12

10

D3067-1

Manufactured No

180

Each

127.0000

1

10

D3067-1

End Plate

**

12.02.21

Location

Loc Qty

Loc Code

WA

120

78022

120

WA016

7

67582

2

68214

1

76179

4

10

AN3-35A

Purchased No

250

Each

243.0000

2

20

AN3-35A

Bolt

**

12/2/27 SP

Location

Loc Qty

Loc Code

ST353

243

119449

43

120187

200

120781

D3235-1

Manufactured No

250

Each

47.0000

2

20

D3235-1

Mounting Lug

**

12/2/28 (u) SP

Location

Loc Qty

Loc Code

ST481

47

75547

47

77566

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 16/01/2012

Required Date: 09/03/2012

Start Qty: 10.00

Required Qty: 10.00

D3278-041 Manufactured No

250 Each 11.0000 1 10

D3278-041

Support Assembly

**

78794

Location

Loc Qty

Loc Code

ST481

11

76169

11

AN960JD416 NAS1149D0463J Purchased No

250 Each 0.0000 16 160

AN960.ID416

Washer

**

119075

AN960JD516 NAS1149D0563J Purchased No

250 Each 0.0000 4 40

AN960.ID516

Washer

**

119717

AN5-36A Purchased No

250 Each 245.0000 2 20

AN5-36A

Bolt

**

78537

Location

Loc Qty

Loc Code

ST340

245

119641

45

120187

200

D2618 Manufactured No

250 Each 152.0000 2 20

D2618

Bushing

**

78537

Location

Loc Qty

Loc Code

ST012

152

76130

52

77563

100

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 16/01/2012

Required Date: 09/03/2012

Start Qty: 10.00

Required Qty: 10.00

D2230-3 Manufactured No

250 Each 72.0000 4 40

D2230-3

Lug

**

78 593

[Handwritten signature]

Location

Loc Qty

Loc Code

ST480	72	
53881	4	
70973	1	
75546	1	
76642	66	

D2856-400 Manufactured No

250 f 113.7673 1.2 12

D2856-400

Abraison Strip

**

[Handwritten signature]

Location

Loc Qty

Loc Code

ST409	113.767258	
63735	0.6696	
68076	0.3149	
71164	21.66	
73491	91.122758	

*** cut (2) at 7.20" (D2856-400-720) ***

MS21042L3

Purchased No

250 Each 5,839.000 2 20

MS21042L3

Nut

**

[Handwritten signature]

Location

Loc Qty

Loc Code

ST300	5839	
117441	16	
117885	32	
118451	5	
118927	3	
119017	5309	
119075	474	

73491

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 16/01/2012

Required Date: 09/03/2012

Start Qty: 10.00

Required Qty: 10.00

AN4-13A Purchased No

250 Each 1,478.000 8 80

AN4-13A

Bolt

**

Location

Loc Qty

Loc Code

ST357

1478

119449

478

120187

1000

120187

MS21042L5 Purchased No

250 Each 2,018.000 2 20

MS21042L5

Nut

**

Location

Loc Qty

Loc Code

ST300

2018

116105

5

116548

43

117611

50

118179

420

119109

1500

118179

MS21042L4 Purchased No

250 Each 7,507.000 8 80

MS21042L4

Nut

**

Location

Loc Qty

Loc Code

ST300

7507

117441

67

117601

342

118451

133

119017

1965

119075

5000

119075

AN960JD10 NAS1149D0363J Purchased No

250 Each 0.0000 4 40

AN960JD10

Washer

**

January-16-12 7:41:05 AM

Shop Packet Print

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DESIGN <i>GP</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07 06 04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
DATE: 12/6/16
BY: 787-80 MCO
12/6/16

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

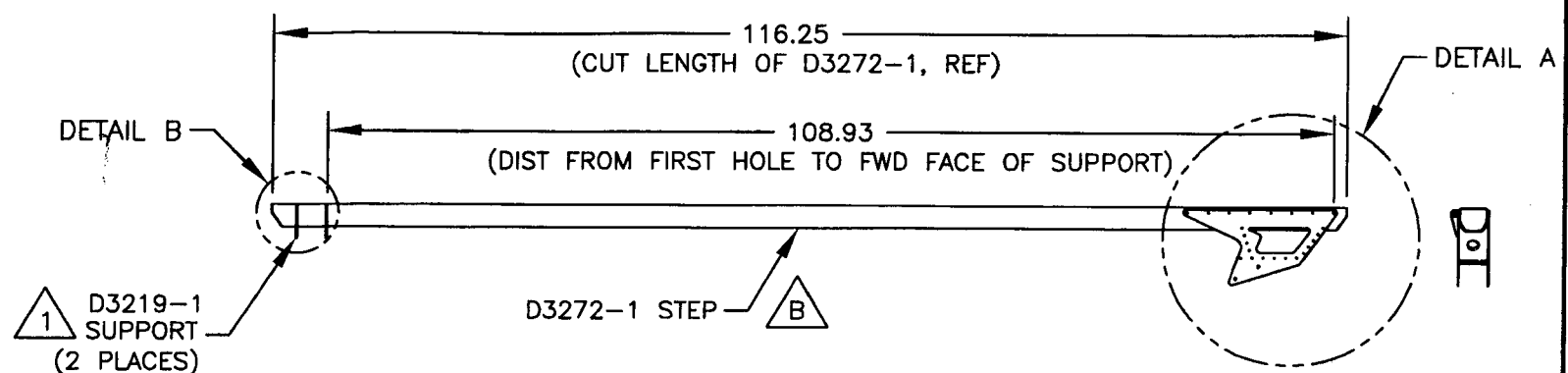
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

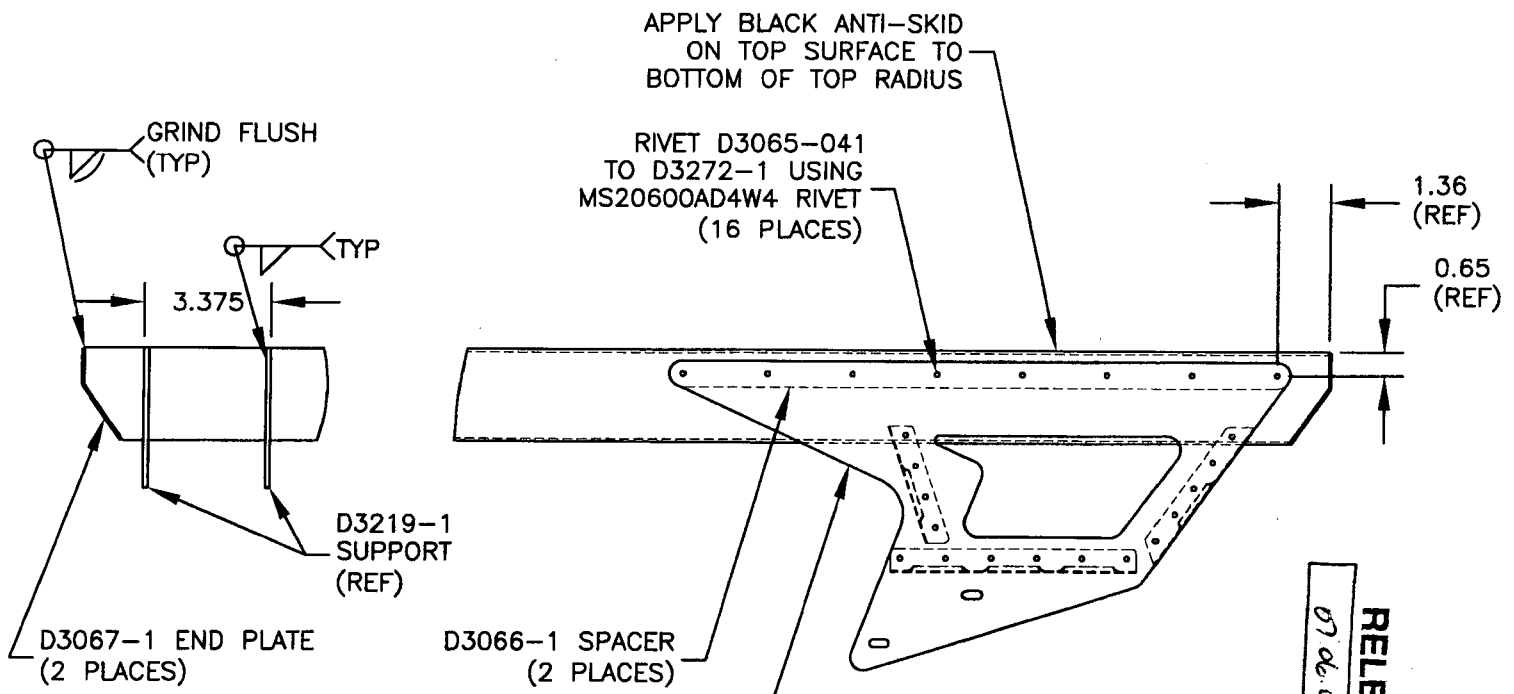
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78780



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



DETAIL B
(SCALE 1:5)

DETAIL A
(SCALE 1:5)

RELEASED
07.06.04

DESIGN	CHCKD	APPROVED	DRAWING NO.	REV. B
DATE			D3272	SHEET 2 OF 3
07.05.18			STEP ASSEMBLY, HI LONG	SCALE
				1:20

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DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

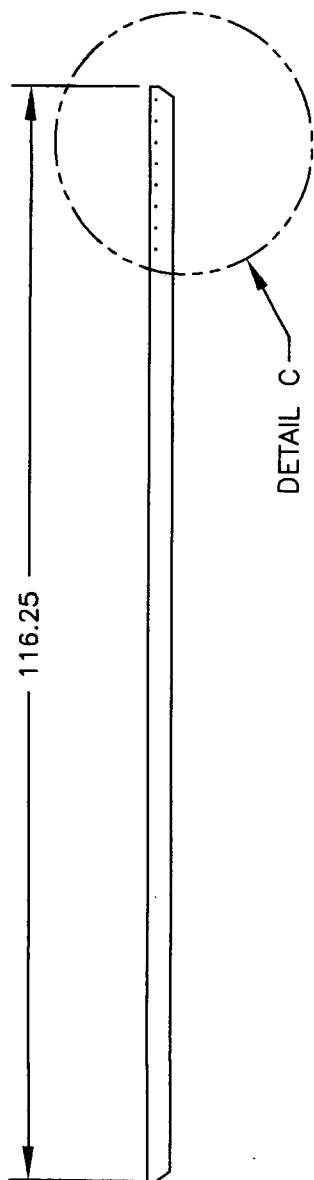
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

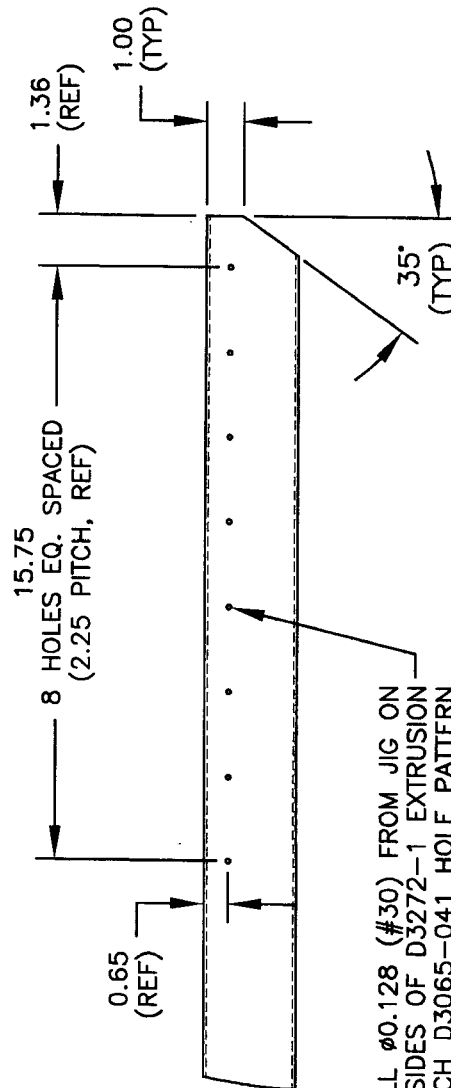
NOTE: Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG		SCALE 1:20



B **D3272-1 STEP**
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

RELEASED

07.06.04

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.